

# Work Order ID 51909

Wednesday, September 09, 2009 11:11:14 A



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Item ID:	D3791-1	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Wearplate					
Start Date:	9/10/2009	Start Qty:	12.00		Cust Item ID:	
Required Date:	9/18/2009	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>RD mfr</u>	Date:	<u>09-9-09</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3791	Rev A								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	304 263								
	Memo	0.00							
	1-Cut as per Dwg D3791								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

IB 9-9-23

IB 9-9-23

(12)

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Item ID: D3791-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Wearplate

Start Date: 9/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00							
			27 502/02/24			(X/2)	/		
130  Brake NC Brake NC	NC BRAKE  Memo 1-Deburr if necessary 2-Form on Brake as per Dwg D3791 using Jigs	0.00 0.00							
			SB 09/09/25			12			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo <del>Ensure joggle as per dwg D3429</del> no joggle S	0.00 0.00							
			27 502/02/25			(X/2)	/		

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Item ID: D3791-1

Revision ID: A

Item Name: Wearplate

Start Date: 9/10/2009 Start Qty: 12.00

Required Date: 9/18/2009 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150



Large Fab

Large Fab

Large Fab

Memo

1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: 11/12272

0.00

0.00

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

EL 9-9-29 (XK2)






(412) /



(412) /




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Required Date:	9/18/2009	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  M109091  Memo START TIME: 2:15pm OVEN TEMPERATURE: 320°= FINISH TIME: 2:45pm	0.00  0.00				(X12)	Ø		
190  QC Quality Control	QC3- Inspect Part Finish  Memo BR	0.00  0.00		09/10-1		(12)			
200  Packaging Packaging	Identify as per dwg & Stock Location: FP-17  Memo	0.00  0.00		09/10/01		(X12)	Ø		



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Item ID: D3791-1 Accept  Setup Start   
Revision ID: A Stop   
Item Name: Wearplate  
Start Date: 9/10/2009 Start Qty: 12.00  Cust Item ID:  
Required Date: 9/18/2009 Req'd Qty: 12.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

09/10/05   
MF  
09-10-01

# Picklist Print

Page 1

Wednesday, September 09, 2009 11:11:13 AM

Work Order ID: 51909



Parent Item: D3791-1RevA



Parent Item Name: Wearplate

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

261.2310

3.6846



304/316 Sheet .063



18 9-9-03

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

261.2309737

106860

16.018

111924

33.0549737

112290

36.8947

112442

79.2633

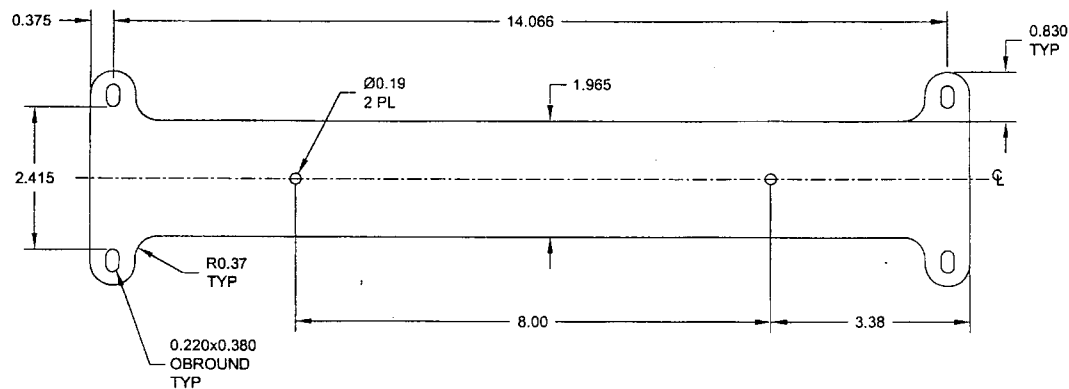
112567

96

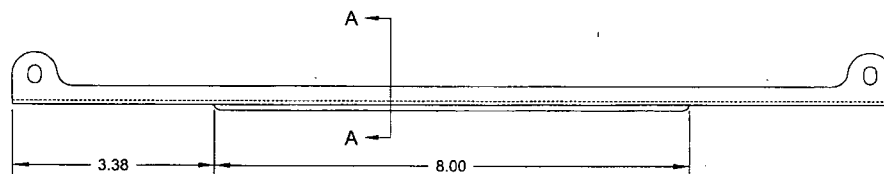
111323

112240 x 6 = 1.8423  
112442 x 35 = 1.5350  
111323 x 1 = .3070

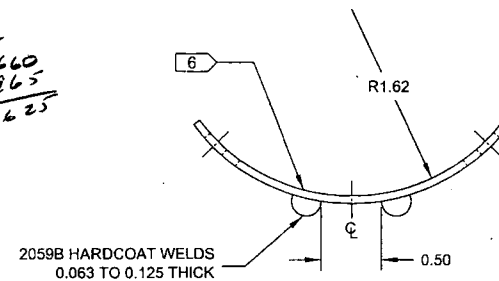




**D3791-1F FLAT PATTERN**



**D3791-1 WEARPLATE**  
(MAKE FROM D3791-1F)



**SECTION A-A**  
SCALE 2X

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 51909

**RELEASED**  
08.05.13

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

A		NEW ISSUE		PH	08.05.13
REV.		DESCRIPTION		BY	DATE
DESIGN		PH		<b>DART AEROSPACE USA, INC</b>	
DRAWN		PH		PORT HADLOCK, WA	
CHECKED		PH		DRAWING NO.	REV. A
MFG. APPR.		PH		D3791	SHEET 1 OF 1
APPROVED		PH		TITLE	SCALE
DE APPR.		PH		WEARPLATE	NTS
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